

Work Order ID 145071

145071

Page 1

Thursday, May 12, 2016 1:39:31 PM

RUSH

Item ID: D4682-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate Assembly

Start Date: 5/6/2016 Start Qty: 3.00

3

Cust Item ID:

Required Date: 5/18/2016 Req'd Qty: 3.00

3

Customer:

Reference: DAS

Approvals:

Process Plan:

13

9-89

Date: MAY 12 2016

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4682

D

110

0.00

110

Waterjet

FLOW CNC Waterjet

Memo

1.02

1-Cut as per dwg D4682-1

prog rev: D

dwg rev: D

2-Deburr if required

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.03

4

DC 16/05/16

4

DC 16/05/16

Work Order ID 145071

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145071

Page 2

Item ID: D4682-041

Accept

N900040100

Setup Start

NS1

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Item Name: Wearplate Assembly

Start Date: 5/6/2016 Start Qty: 3.00

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Cust Item ID:

Required Date: 5/18/2016 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.06				<u>(4)</u>			DAS 38 9-89 MAY 18 2016
140 *140* Small Fab Small Fab	Memo Form as per dwg D4682 FWD END MUST ALSO BE FORM AS PER DWG	0.07 0.75			DAS 30 9-89	<u>4</u>			MAY 17 2016
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.06				<u>(4)</u>			DAS 38 9-89 MAY 18 2016

Work Order ID 145071

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Page 3

Item ID: D4682-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Assembly
Start Date: 5/6/2016 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 5/18/2016 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Large Fab Large Fab	Weld per dwg A/R Hardcoat S.S. Batch: <u>m130145</u> Memo *** FWD END MUST BE FORM AS PER DWG*** 1- Weld hardcoat as per dwg and QSI004 2- Weld shim to wearplate as per dwg and QSI004 A/R s.s. rod Batch #: <u>m123823</u>	0.00 2.49				<u>2</u>			<u>EL/PT</u> 19/05/16
170 *170* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				<u>(2)</u>	<u>16-05-19</u>		DAS 9 9-89
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.06				<u>(2)</u>	<u>16-05-19</u>		DAS 9 9-89

Work Order ID 145071

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145071

Page 4

Item ID: D4682-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Assembly
 Start Date: 5/6/2016 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 5/18/2016 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* SprayPaint Spray Painting	Memo 1- Apply Rockguard on entire concave surface as per dwg A/R Rockguard Batch: <u>134681</u> 2- Indicate FWD direction as shown using white paint marker(SEE NOTE 11)	0.00 0.24				<u>2</u>			DAS 41 9-89 16-5-19
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.06				<u>(2)</u>			DAS 38 9-89 MAY 19 2016
210 *210* Packaging Packaging	Identify as per dwg & Stock Location: <u>5HP3</u> Memo	0.00 0.03				<u>2</u>		MAY 19 2016	DAS 4 9-89

Work Order ID 145071***145071***

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Thursday, May 12, 2016 1:39:31 PM

Item ID: D4682-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Assembly
Start Date: 5/6/2016 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 5/18/2016 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.30							
Quality Control									

16/5/24 JF
2m 16/05/20

Picklist Print

Thursday, May 12, 2016 1:39:30 PM

Page 1

Work Order ID: 145071

145071

Parent Item: D4682-041

D4682-041

Parent Item Name: Wearplate Assembly

Start Date: 5/6/2016

Required Date: 5/18/2016

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A 13.03.27 NEW ISSUE DD VERF:JLM IPP
REV:B 13.11.14 AS PER DWG REV.B DD VERF:JLM IPP REV:C
14.03.13 AS PER DWG REV.PC1 DD VERF:JLM IPP REV:D 14.11.24
AS PER DWG REV.C DD VERF:JLM IPP REV:E 15.06.10 AS PER
DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4682-9		Manufactured	No				Each	14.0000		3			
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D4682-9

Wearplate Shim

**

19/05/16
PT

Location	Loc Qty	Loc Code
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WA002	14	
141356	14	

M304S18GA		Purchased	No			110	sf	218.2905	1.06	3.347368			
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M304S18GA

304/316 .050 Sheet

**

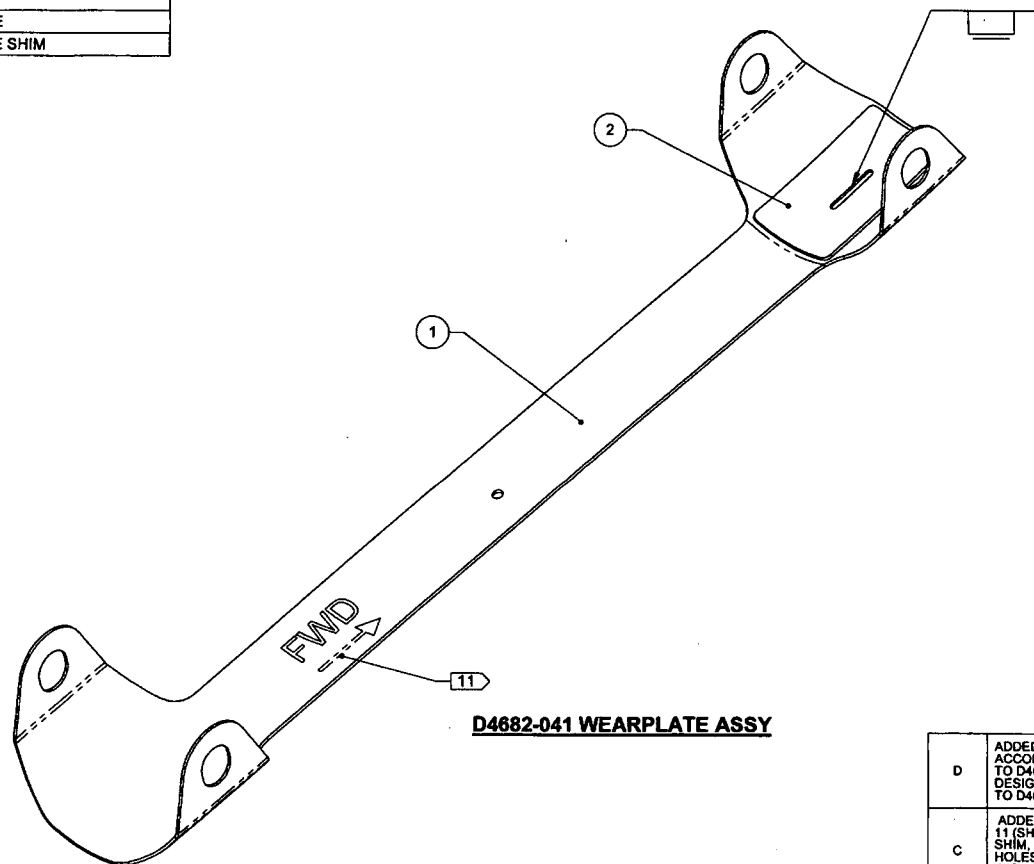
or 16/05/18

Location	Loc Qty	Loc Code
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MAT020	79.521	
M133328	67.796	
M133587	11.725	
MAT20	128	
M134580	128	
TPI	10.76946	
M134604	10.76946	

4.2

ITEM	QTY	P/N	DESCRIPTION
	X	D4682-041	WEARPLATE ASSY
1	1	D4682-1	WEARPLATE
2	1	D4682-9	WEARPLATE SHIM



D4682-041 WEARPLATE ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.1
- 7) WEIGHT: 1.06 lbs
- 8) WELDING: PER QSI 004
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK PER QSI 005 SECTION 4.9
- 10) OPEN UP DRAIN HOLE IF NECESSARY TO $\phi 0.188$ AFTER APPLYING TEXTURED COATING
- 11) INDICATE FWD DIRECTION IN LOCATION SHOWN USING WHITE PAINT MARKER

RELEASED
2015-06-08
ECN 15-551

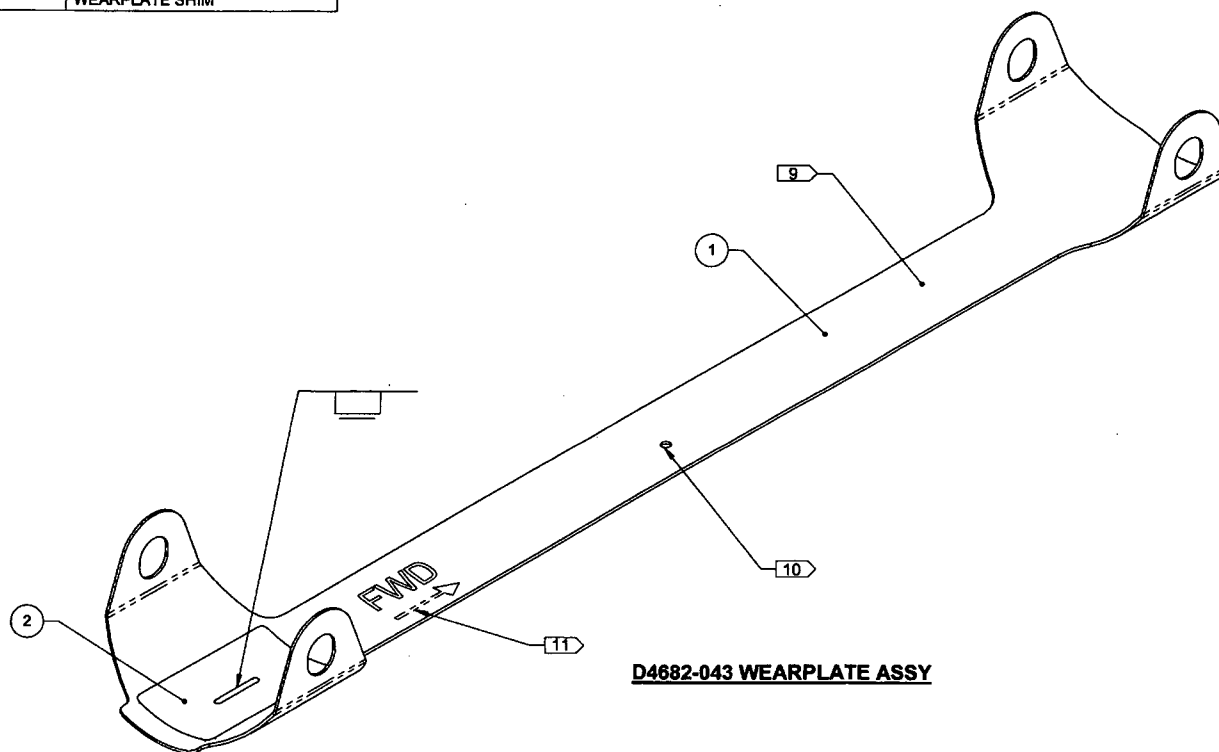
D	ADDED SHT 2, WEARPLATE FORMING MODIFIED TO ACCOMMODATE MATERIAL SPRING BACK, ADD FWD BEND TO D4682-041. MINOR DIM CHANGES, D4682-9 RE-DESIGNED, D4682-11 REMOVED, ADD FWD INDICATION TO D4682-045/7	AP	15.03.24
C	ADDED FWD INDICATION ON D4682-041/043 PER NOTE 11 (SHT 1). D4682-11 SHIM (SHT 8) REPLACED D4769-3 SHIM, VARIOUS DIMENSIONAL CHANGES TO THRU HOLES AND OVERALL DIMENSIONS OF D4682-1/3/5/9 PARTS. REFERENCE TO PLUS ONE ROCKGUARD REMOVED.	AP	14.07.28
B	THRU HOLES NOW SLOTS, VARIOUS DIMENSIONAL CHANGES, $\phi 0.188$ HOLE MOVED (B5-3). UPDATED PART WEIGHTS, REMOVED GRAIN DIR ON ALL PARTS D4769-3 WAS D4682-9 ON D4682-041 WEARPLATE ASSY.	AP	13.09.10
A	NEW ISSUE	AP	13.02.13
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	DD	D4682	SHEET 1 OF 8
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
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APPROVED

w/o 145071

2m 16/05/03

ITEM	QTY -043	P/N	DESCRIPTION
	X	D4682-043	WEARPLATE ASSY
1	1	D4682-3	WEARPLATE
2	1	D4682-9	WEARPLATE SHIM



D4682-043 WEARPLATE ASSY

NOTES:

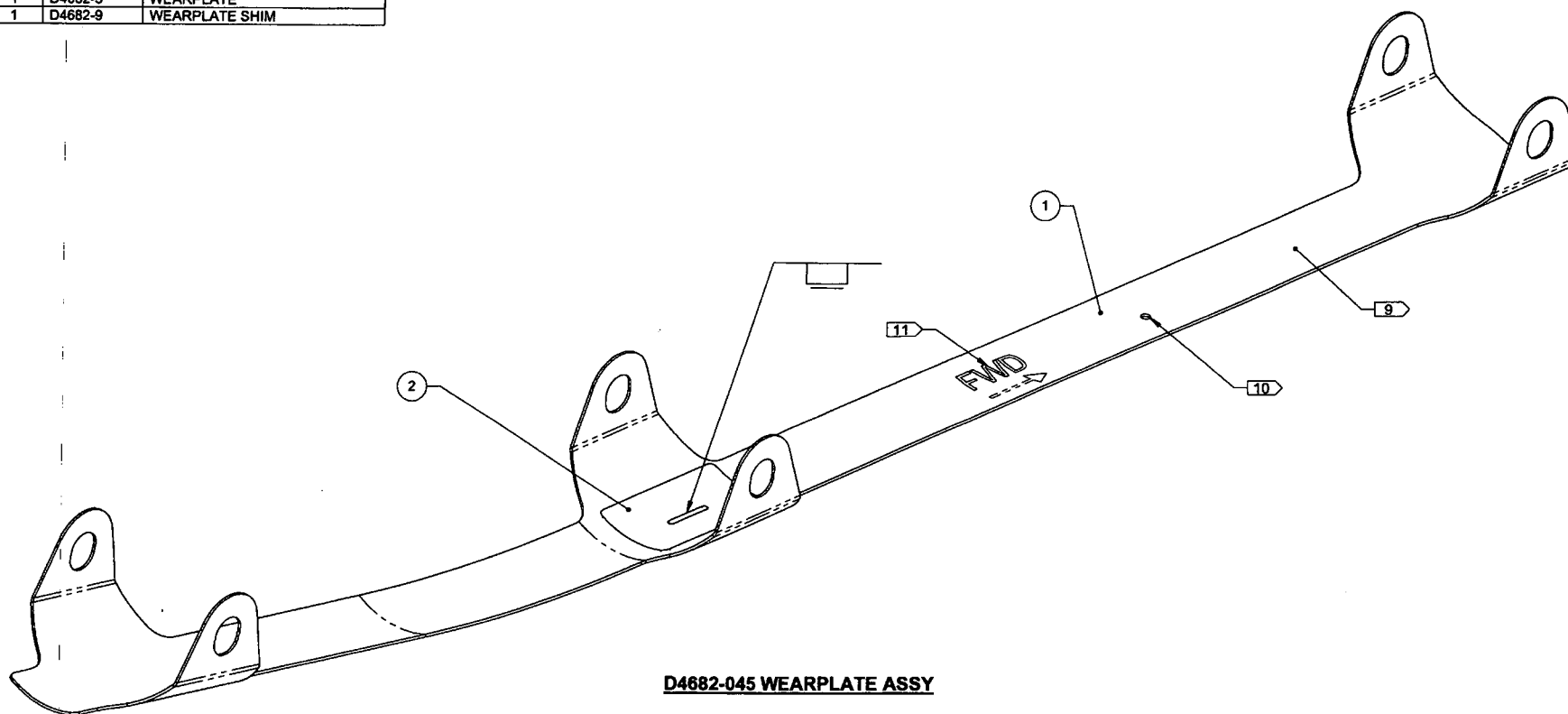
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.1
- 7) WEIGHT: 1.20 lbs
- 8) WELDING: PER QSI 004
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK PER QSI 005 SECTION 4.9
- 10) OPEN UP DRAIN HOLE IF NECESSARY TO $\varnothing 0.188$ AFTER APPLYING TEXTURED COATING
- 11) INDICATE FWD DIRECTION IN LOCATION SHOWN USING WHITE PAINT MARKER

RELEASED
2015-06-08

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ITEM	QTY	P/N	DESCRIPTION
	X	D4682-045	WEARPLATE ASSY
1	1	D4682-5	WEARPLATE
2	1	D4682-9	WEARPLATE SHIM



D4682-045 WEARPLATE ASSY

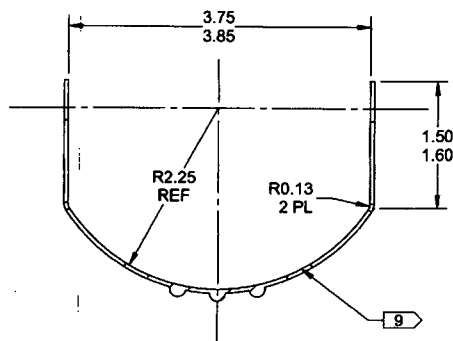
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.1
- 7) WEIGHT: 1.85 lbs
- 8) WELDING: PER QSI 004
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK PER QSI 005 SECTION 4.9
- 10) OPEN UP DRAIN HOLE IF NECESSARY TO $\varnothing 0.188$ AFTER APPLYING TEXTURED COATING
- 11) INDICATE FWD DIRECTION IN LOCATION SHOWN USING WHITE PAINT MARKER

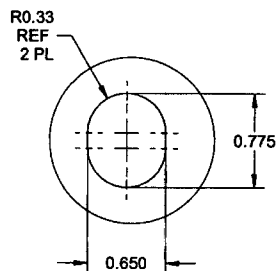


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2015-06-08

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	CHECKED	AJS	DRAWING NO.	REV. D
	MFG. APPR.	DD	D4682	SHEET 3 OF 8
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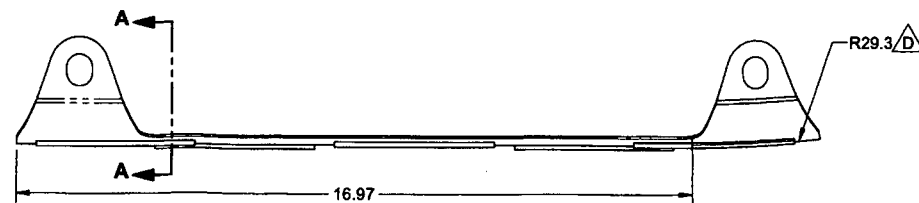
SECTION A-A
SCALE 2X



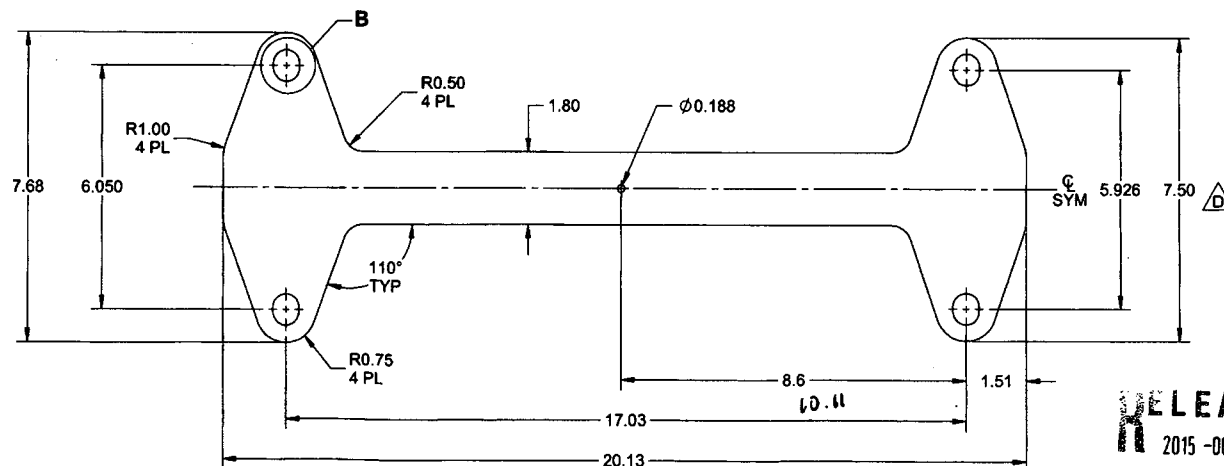
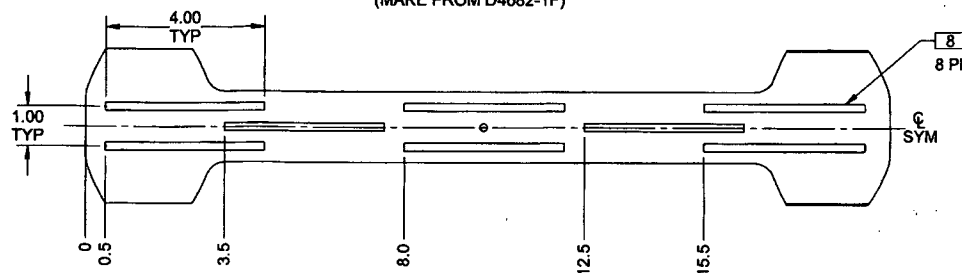
DETAIL B
SCALE 3X
4 PL

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR AMS 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, REF DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.99 lbs
- 8) WELDING: PER QSI 004. APPLY LAYER OF 2059B HARDCOAT WELD TO 0.063 - 0.125 HIGH AFTER BENDING
- 9) FORM USING R1.9 DIE



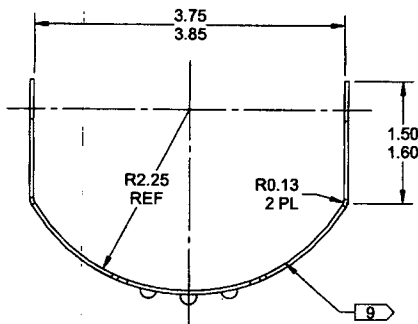
D4682-1 WEARPLATE
(MAKE FROM D4682-1F)



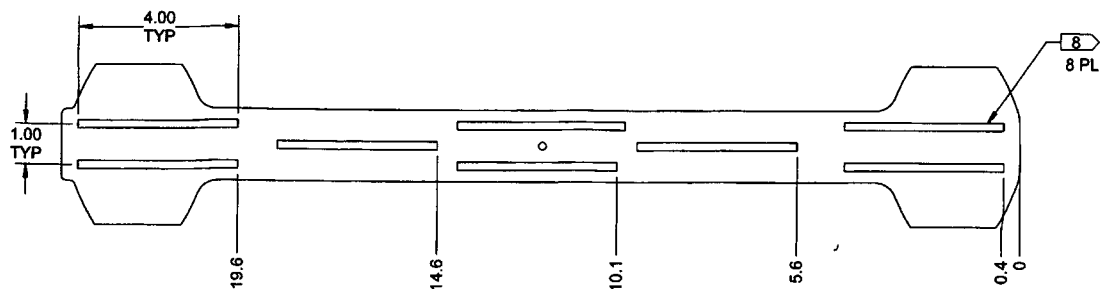
D4682-1F WEARPLATE
(FLAT PATTERN)

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2015-06-08

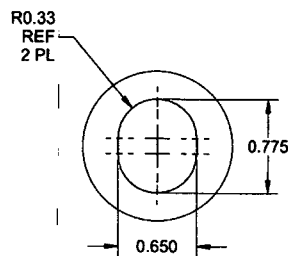
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	MFG. APPR.	DD	D4682	SHEET 4 OF 8
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	DE APPR.	DS	WEARPLATE ASSY	NTS
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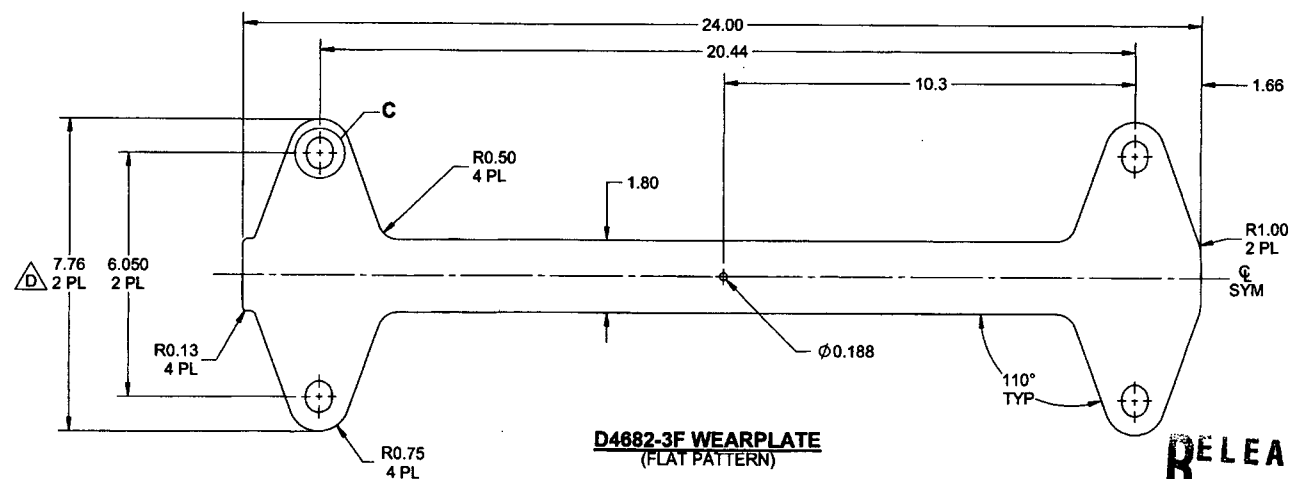
D4682-3 WEARPLATE
(AUXILIARY VIEW) D



D4682-3 WEARPLATE
(MAKE FROM D4682-3F)



DETAIL C
SCALE 3X
4 PL



D4682-3F WEARPLATE
(FLAT PATTERN)

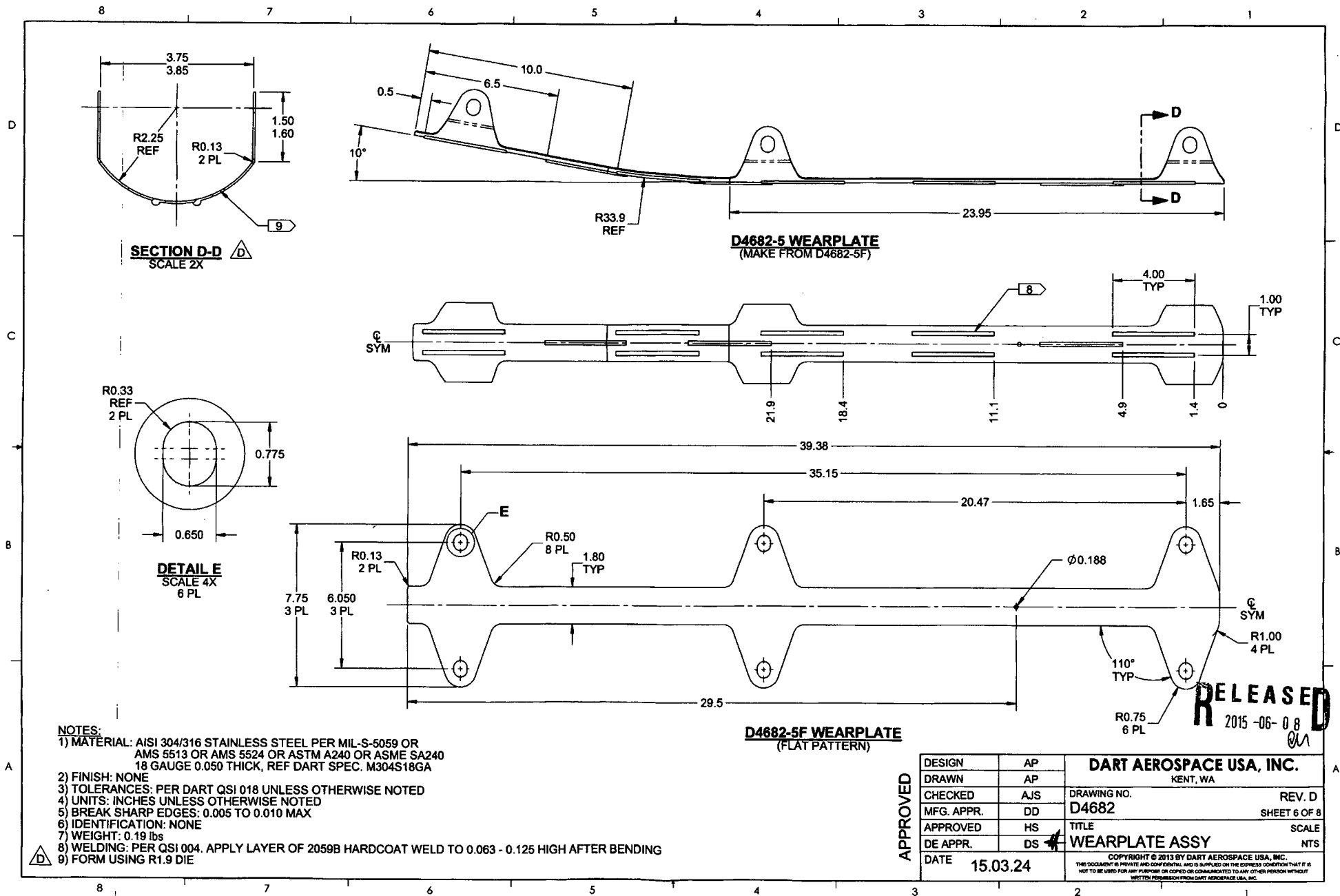
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR AMS 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, REF DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.12 lbs
- 8) WELDING: PER QSI 004. APPLY LAYER OF 2059B HARDCOAT WELD TO 0.063 - 0.125 HIGH AFTER BENDING
- 9) FORM USING R1.9 DIE

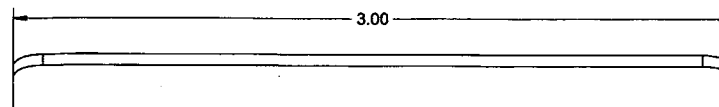
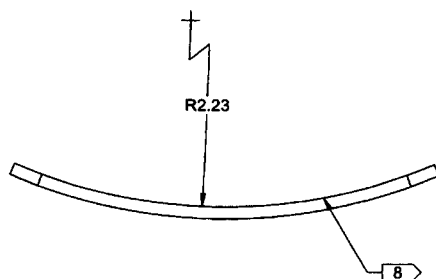
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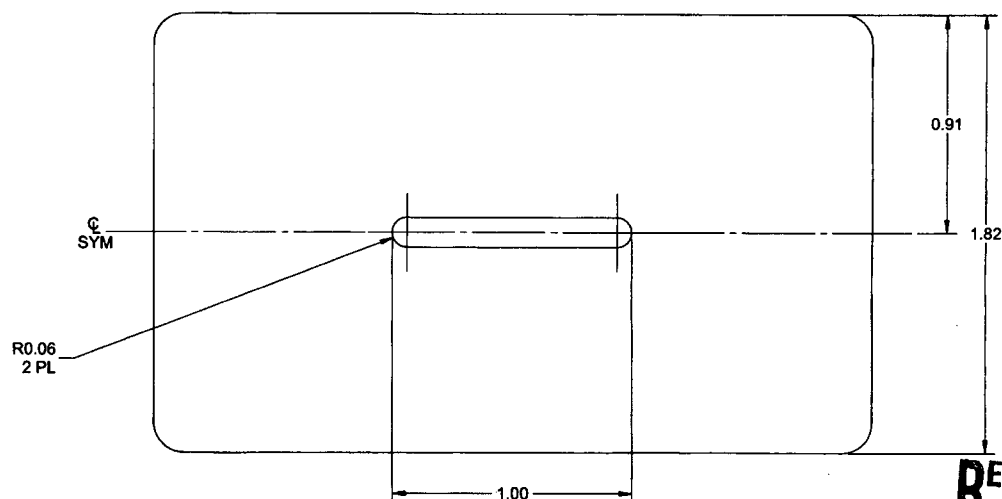
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2015-06-08



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	CHECKED	AJS	DRAWING NO.	REV. D
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D4682-9 WEARPLATE SHIM
(MAKE FROM D4682-9F)



D4682-9F WEARPLATE SHIM $\triangle$
(FLAT PATTERN)

RELEASED
2015-06-08

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR AMS 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, REF DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.08 lbs
- 8) FORM USING R1.9 DIE

APPROVED

DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	DD	D4682	SHEET 8 OF 8
APPROVED	HS	TITLE	SCALE
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